

Work Order ID 147369-2

Wednesday, June 08, 2016 3:06:12 PM

147369

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Item ID: D4617-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Emergency Escape Ladder

Stop *NS2*

Start Date: 6/21/2016 Start Qty: 1.00

Required Date: 6/24/2016 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

1
1
SH

Approvals: Process Plan: MLS

Date: JUN 10 2016 Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4617	B								
100		0.00							

100

CNC Bend 1

CNC Delta 100 Bender

Memo

0.00

BEND RAIL AS PER DWG AND TO FIT PROFIL OF WELDING JIG DT9803
(ON LENGTH OF TUBE, 20 FEET MAKES 2 RAILL)

***BENDER SET UP SAME AS BASKET RIB, TOWERS ON NARROW,
RAM AT 2000 PTS FOR BENDING RADIUS***

3 16-7-20

110

110

Large Fab

Large Fab

Weld per dwg A/R 4130 rod Batch: M12705

0.00

Memo

0.32

1- CUT STEPS AS PER DWG AND PREP FOR WELDING

2- CUT RAIL

3- INSTALL PARTS ON WELDING JIG DT9803 AND WELD AS PER DWG

3 16-7-20

Costed

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Revision ID:

Item Name: Emergency Escape Ladder

Start Date: 6/21/2016 Start Qty: 1.00

Required Date: 6/24/2016 Req'd Qty: 1.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				(3)	16-07-21	9	DAS 9 9-89
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(3)	16-07-21	9	DAS 9 9-89
140 *140* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00							

U/A
PD 16-07-26

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2- Install decals as per dwg

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NS1

Stop *NS2*

Customer:

Run Start *NR1*

Stop *NR2*

NR2

180

Quality Control

190

Category	Item	Quantity	Unit Price	Total Price
Packaging	Box	10	5.00	50.00
	Label	100	0.50	50.00
Transportation	Truck	1	100.00	100.00
	Truck	1	100.00	100.00
Labor	Worker	10	10.00	100.00
	Worker	10	10.00	100.00
Material	Steel	100	1.00	100.00
	Steel	100	1.00	100.00
Energy	Electricity	100	1.00	100.00
	Electricity	100	1.00	100.00
Maintenance	Oil	100	1.00	100.00
	Oil	100	1.00	100.00
Insurance	Life	100	1.00	100.00
	Life	100	1.00	100.00
Miscellaneous	Tools	100	1.00	100.00
	Tools	100	1.00	100.00

200

Quality Control

Picklist Print

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Wednesday, June 08, 2016 3:06:14 PM

Work Order ID: 147369

147369

Parent Item: D4617-041

D4617-041

Parent Item Name: Emergency Escape Ladder

Start Date: 6/21/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.04.12 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.750W.035		Purchased	No			100	f	88.0000	20	21.05263			
M4130NT0 750W 035									**				
4130 RD TUBE .750 X .035W													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT033				88					
				121910				88					
M4130NT0.750W.035		Purchased	No			110	f	88.0000	5.06	5.326316			
M4130NT0 750W 035									**				
4130 RD TUBE .750 X .035W													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT033				88					
				121910				88					
D4617-045		Manufactured	No			170	Each	0.0000	4				
D4617-045									**				
Clamp Assembly													
D4618-041		Manufactured	No			170	Each	17.0000	4				
D4618-041									**				
Clamp Assembly Cover													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				st113				17					
				139782				17					
D4621-1		Manufactured	No			170	Each	0.0000	2				
D4621-1									**				
Decal													
D4621-3		Manufactured	No			170	Each	0.0000	1				
D4621-3									**				
Decal													

JUL 27 2016

Picklist Print

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Work Order ID: 147369

147369

Parent Item: D4617-041

D4617-041

Parent Item Name: Emergency Escape Ladder

Start Date: 6/21/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

D4625-1

Manufactured No

170

Each

56.0000

4

4 12

D4625-1

Tube Cap

Location

Loc Qty

Loc Code

ST114

56

83122

56

12

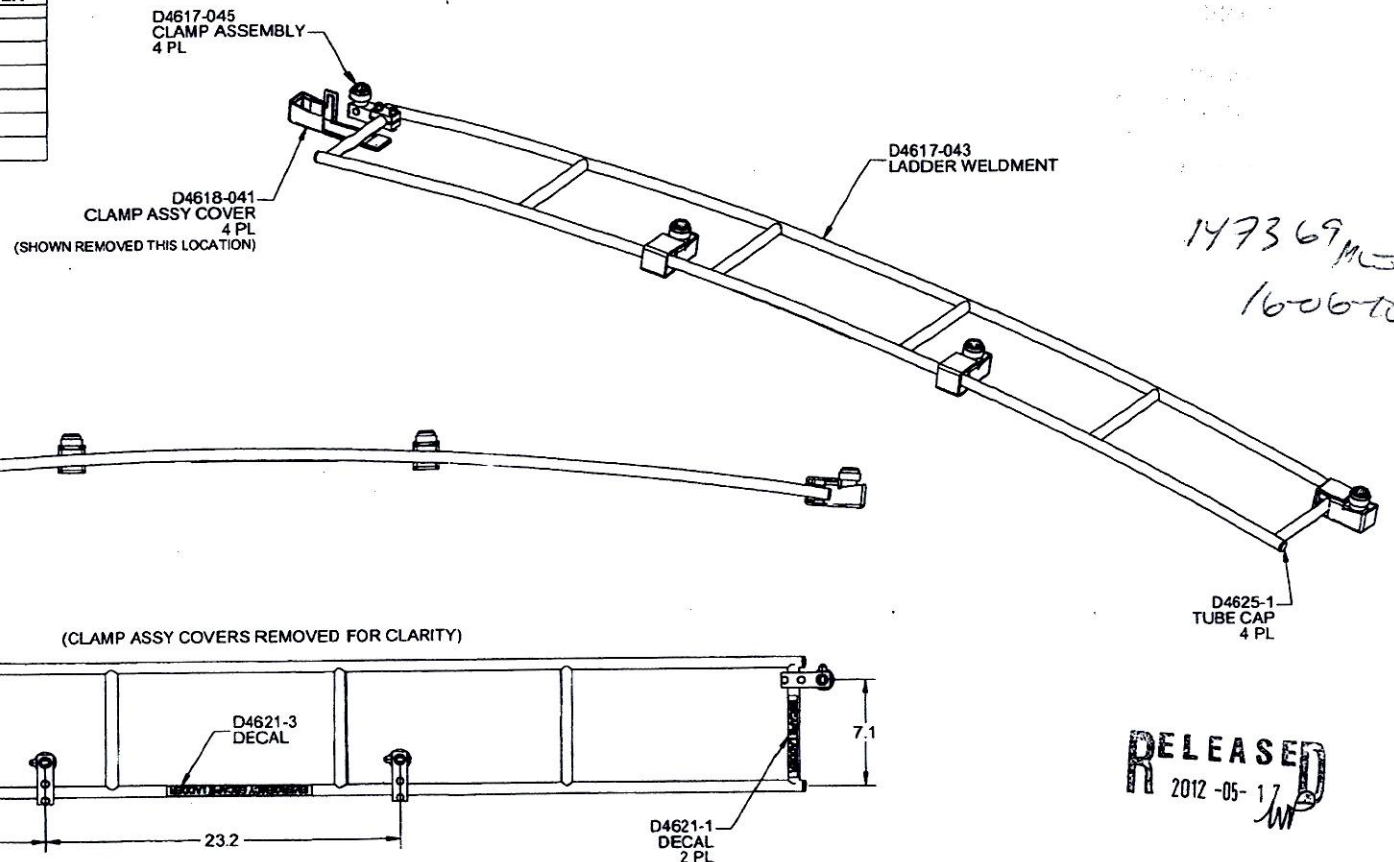
DAS

6

9-89

JUL 27 2016

ITEM	QTY	P/N	DESCRIPTION
	X	D4617-041	EMERGENCY ESCAPE LADDER
1	1	D4617-043	LADDER WELDMENT
2	4	D4617-045	CLAMP ASSY
3	4	D4618-041	CLAMP ASSY COVER
4	2	D4621-1	DECAL
5	1	D4621-3	DECAL
6	4	D4625-1	TUBE CAP



D4617-041 EMERGENCY ESCAPE LADDER

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4617-041" AND BATCH NUMBER PER QSI 044 6.6
 - 7) WEIGHT: 6.48 lbs

B	75.4-75.5 WAS 75.7 (C4-2) WASHER WAS NAS 1149C0463R, QTY 3 ON SHT 4. 0.753-0.756 WAS 0.750-0.753 (B4-5)	RP	12.05.01
A	NEW ISSUE	RP	12.04.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.		D4617	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		EMERGENCY ESCAPE LADDER	NTS
DATE	12.05.01	COPYRIGHT © 2012 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2012-05-17